

PROMASTIC 600 CT (paint shop process)

INTENDED USE

METAL FINISHING

A high solids, low VOC, two pack epoxy 'one coat finish' or primer undercoat. It is designed for use on OEM heavy metal parts or structures which are subject to moderate impact damage due to mechanical handling, or exposure to mild chemicals.

For exterior applications where colour and gloss retention are important Promastic 600CT should only be used as a high performance primer/undercoat when it should be overcoated with 2 Pack Acrylic Polyurethane or Prokote 80. This is necessary because epoxy systems discolour and chalk within 12 months when exposed to UV light.

VEHICLE REFINISH and the ORIGINAL COATING of VEHICLES or TRAILERS

Used as a 'one coat' mid sheen coating for commercial vehicles or vehicle components e.g. tail lifts, trailers and sub frames usually in dark greys or black. When exposed to direct sunlight the colour will fade and a white bloom will appear on the surface, so Promastic 600CT should only be used on chassis with sideskirts, or on chassis and components not exposed to direct sunlight. Otherwise Promastic 600CT should be overcoated with a suitable 2 Pack Acrylic Polyurethane; seek advice from Manor Coating Systems Technical Department.

VOC classification 2004/42/IIB(d)(415) when used as a finish unthinned

VOC classification 2004/42/IIB(c)(465) when used as a primer and thinned up to 15% with 2 Pack Epoxy Thinner.

Features

- outstanding adhesion to structural steel plate, stainless steel, aluminium and GRP. Tested with pressure wash to 3000 p.s.i. on a cross hatch coating.
- superb humidity, chemical and chip resistance
- rapid hardness development (Air dry gives a touch dry of 60-90 minutes and dry to handle after 6-8 hours. Force dry at 80 C for one hour; ensures the chassis can be worked on immediately)

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application.

SUITABLE SUBSTRATES AND PREPARATION

Untreated steel, for best results blast clean prior to painting to SA 2 1/2, otherwise manually abrade using powered hand tools and abrasives to ST2.

GRP thoroughly abrade the surface prior to painting.

Previously painted steel; remove rust back to sound metal. Remove loose or flaky paint. Bring forward by patch priming. Sound previously painted surfaces should be lightly abraded prior to application in order to promote adhesion.

Remove dust. Remove oil or grease with Panel Cleaner. If using a waterborne degreaser remove fully. Test a small area prior to painting and assess adhesion.

Galvanised steel; abrade and pre-treat with Manor 1 Pack Etch Primer in accordance with data sheets for these products.

Other substrates; seek advice from Manor Coating Systems Technical Department

AVAILABILITY

Most BS and RAL colours available from the Manormix Scheme in 5 litre containers

The accuracy of the colour match will only be approximate due to the product composition.

Epoxyes that are not topcoated will chalk, fade and may yellow and darken. The yellowing tendency is particularly noticeable in pastel colours.

PRODUCT INFORMATION

(TYPICAL FIGURES)

Composition	Two pack epoxy cured with a polyamidoamine adduct containing pigment extenders and modified zinc phosphate anti-corrosive pigment.
Volume Solids	53% mixed unthinned
Weight Solids	65% mixed unthinned
VOC content	415 g/litre unthinned.
Supply Viscosity	3 poise at 20C
Typical film thickness	<p>One coat can be applied as follows: Airless spray, unthinned, 150 microns dry film thickness (approximatley 300 microns wet film thickness) Brush / roller, unthinned, 50 microns dry film thickness (approximatley 100 microns wet film thickness)</p> <p>The number of coats will depend on the area of end use and whether the product is being used as a primer or finish.</p> <p>Typically: 150 microns dry film thickness when used as a primer under 2 Pack Acrylic Polyurethane for inland exposure areas not subject to harsh chemicals 300 microns dry film thickness when used as a primer under 2 Pack Acrylic Polyurethane for coastal exposure areas or those subject to harsh chemicals 300 microns dry film thickness when used as a primer finish on plant and equipment</p> <p>100 microns dry film thickness when used as a maintenance coating on previously painted interior surfaces and 150 microns dry film thickness on bare interior surfaces</p>
Theoretical coverage	3.3 sq metres/litre at 300 microns wet film thickness 9.9 sq metres/litre at 100 microns wet film thickness
Dry heat resistance	120 C Continuous high temperatures will darken the film
Flash Point	Within the range 21-31 C

APPLICATION DETAILS

PREFERABLY BRING PAINT TO 15-25C AND STIR WELL BEFORE USE

Mixing 4 parts Promastic Base to 1 part Promastic Hardener by volume. Mix for at least 5 minutes to ensure base and hardener are fully incorporated unless using 'mix at the tip' spray equipment.

Do not use other hardeners or accelerators with Promastic.

Viscosity
Pot Life Once mixed the product has a workable pot life of approximately 6 hours dependent on temperature.

Airless spray: **cold** Typical tip size 13-18 thou (0.33-0.48mm)
Typical fluid pressure 2500 p.s.i.
heated Not recommended

Conventional spray After adding hardener and stirring thin with up to 15% Manor 2 Pack Epoxy Thinner. Build up coats to required film thickness.

Brush Roller Ready for use when mixed

Thinner 2 Pack Epoxy Thinner

Film thickness per coat

	<u>Dry</u>	<u>Wet</u>
Minimum	75 microns (airless)	150 microns (airless)
Maximum	125 microns (airless)	250 microns (airless)

DRYING AND RECOATING

Approximate drying times at 100 microns d.f.t.

<u>Substrate temperature</u>	<u>Touch Dry</u>	<u>Overcoating times</u>	
		Minimum	Maximum
10C	2 hours	6 hours	2 days (see note)
20C	1 hour	3 hours	2 days (see note)

Note

Full chemical cure is achieved after 3 days at 20 C

Environmental conditions

The air temperature must be above -5 C with a surface temperature 3 C above the dew point and the relative humidity below 90% thus ensuring that the surface is dry and that condensation will not occur during application or drying.

Drying times will be significantly extended in cold conditions.

Curing will slow down or stop if the temperature falls below -5 C and may not resume if the film is allowed to pick up moisture.

Do not apply to external surfaces if the forecast is for rain to fall within the next 4 hours.

In exposed windy conditions a minimum air temperature of 3 C is recommended.

Overcoating / repainting

If required a further coat of the product may be applied or 2 Pack Acrylic Polyurethane may be applied.

After 2 days of air drying between coats it is important to lightly abrade the surface to remove sheen and improve intercoat adhesion.

SHELF LIFE

Store in cool, dry conditions, typically 5-25C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

SAFETY PRECAUTIONS

Refer to Manor Safety Data Sheet

LIMITATIONS

The information given in this data sheet is based on experience and is accurate to the best of our knowledge. No guarantee should be implied however, since the conditions of use are beyond our control. This data sheet does not constitute a specification.

A Painting Guide can be accessed via our website which provides additional information on paint and painting and definitions of terminology.

In case of doubt as to the suitability of the product please consult our Technical Department. If you are advised that the paint can be used in a manner not specified on this datasheet our Technical Department will confirm this to you in writing. Do not use paint prior to receiving this confirmation.

References to other primers, topcoats, cleaners and thinners are to the Manor Product of that name only.

This data sheet supercedes all previous issues.

REFERENCES

Amended date: November 27, 2012

Reference and number:PR-paint shop- 7